

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012252**Date Inspected:** 25-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

**TRIAL ASSEMBLY YARD**

This QA Inspector randomly observed the following work in progress.

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067588 performing Shielded Metal Arc Welding process for weld 060 located on PCMK EP030-001. ZPMC QC Mr. Zhang Qiang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-TC-U4B-FCM-1.

**OBG SEGMENT 7AW-7BW**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067752 performing Shielded Metal Arc Welding process for weld OBW7B-004 located on PCMK side panel splice weld between OBG segment 7AW and 7BW (counter weight side). ZPMC QC Mr. Feng Ya Jun monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

**OBG SEGMENT 6BW**

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 066413 performing Shielded Metal Arc

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Welding process for weld OBW6F-006 located on PCMK counter weight connection plate. ZPMC QC Mr. Zhong Yong Gang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U4-FCM-1.

## CROSS BEAM # 6

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067183 performing Shielded Metal Arc Welding process for weld CB202-006-001 located on PCMK hold back weld between side plate and bottom plate of cross beam 6 west side. ZPMC QC Mr. Zhang Hai Tao monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2212-TC-U4B-FCM-1.

## OBG SEGMENT 7CE

This Quality Assurance (QA) Inspector observed ABF QA Inspectors performing ultrasonic inspection on the weld between edge panel and deck panel (cross beam side). See attached photo.

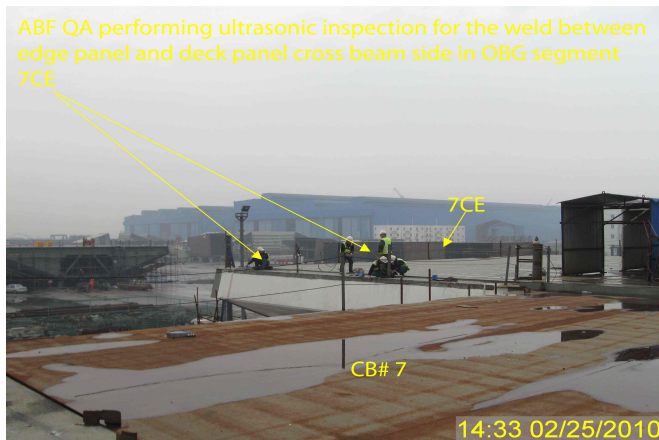
## CROSS BEAM # 5

This Quality Assurance (QA) Inspector observed shifting of cross beam #5 was in progress. See attached photo.

## OBG SEGMENT 6CW-6BW

This Quality Assurance (QA) Inspector observed ABF QA Inspectors performing magnetic particle inspection on the repair areas of the side panel splice weld between OBG segment 6CW and 6BW (cross beam side) .

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer